

Date: Wednesday, 3/8/2006 10:34:08 AM
 User: Kim Johnston

Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
 Job Number : 26099
 Estimate Number : 10266
 P.O. Number : N/A Part Number : D350636013
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D2750 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C1
 Previous Run : 26098 Material : N/A
 Written By : SEE COMMENT (REV) Due Date : 4/15/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.03.08
 Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 001

DT 06/03/21 (1)

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B25384

fm 06-03-09 (1)

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2744

Cap

B24672 BE 06-04-05 (1)

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end fm 06-03-09 (1)

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-3) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 fm 06-03-09 (1)

*****Drill last hole using Dt 8820 locating off last hole drilled*****

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size fm 06-04-04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-3), mark Fwd end for cutting using Drill Jig DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8330

Make sure that wearplate holes are on bottom of tube**

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375" as per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .391" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004, Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

M19101 BE 06-0405

13-Grind welds flush as per Dwg D2750

BE 06-0406

Pm 06-04-04

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 06-04-06

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-04-07

PD 06-04-07

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

B26385

Pm 06-04-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D2743

Crossbolt spacer

B24240 BE 06-04-12 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" \varnothing holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *pm 06-04-07 (1)*

2-Deburr and blow out all chips from inside of tube *pm 06-04-07 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

m100490

Sikaflex expire date: *06-11-01*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

m19101

5-Grind welds flush as per Dwg D2750

BE 06-04-12 (1)

6-Spot face ground handling holes \varnothing 0.750" (8 places)

BE 06-04-12 (1)

7-Deburr holes

BE 06-04-12 (1)

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

PL 06/05/02 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FL 06 05 02 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27421

Blade Fitting, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-1	Blade Fitting, LH	B25111

14.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

15.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

16.0

MS21083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19099

17.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B24843-2

18.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B25914

DL 06/05/02 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B25330 ✓

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B25841 ✓

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 ✓	Insert	M18293 ✓
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M18235 ✓

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M15205

DL 06/05/02 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	AN36A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274 ✓

25.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B24879 ✓

26.0	AN644A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M19073 ✓

27.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614 ✓

28.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

DL 06/05/02 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M14066

DL 06/05/02 (1)

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291

Sikaflex expire date: 11/06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291

Sikaflex expire date: 11/06

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

DL 06/05/02 (1)

31.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FL 06 05 02 (1)

32.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0	D2741	Blade
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
1	D2741	Blade	B25938

B25938 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 20/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:34:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26099

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

m16956 ✓

35.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

m19099 ✓

36.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

m5760

AR 06/05/03 ①

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AR 06/05/03 ①

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev. D

AR 06/05/03 ①

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AR 06/05/04 ①

Job Completion



AR 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

RELEASED
98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44 42	44 42	44 42	44 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
D20 4133 DS	D20 4137 DS
98.01.19 DS	98.10.21 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26099



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

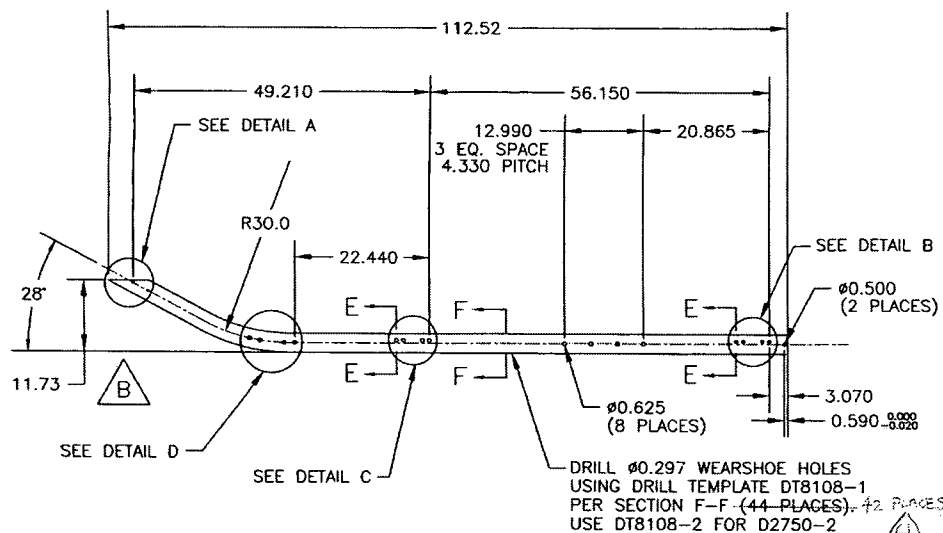
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

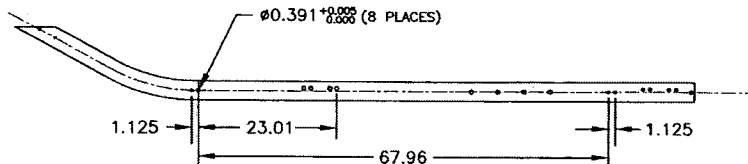
RELEASED
98.12.16 DS

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26099

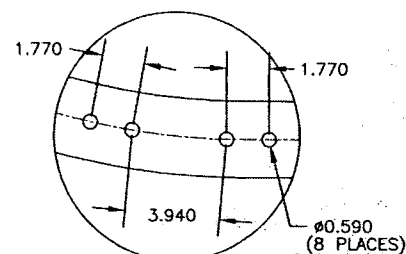
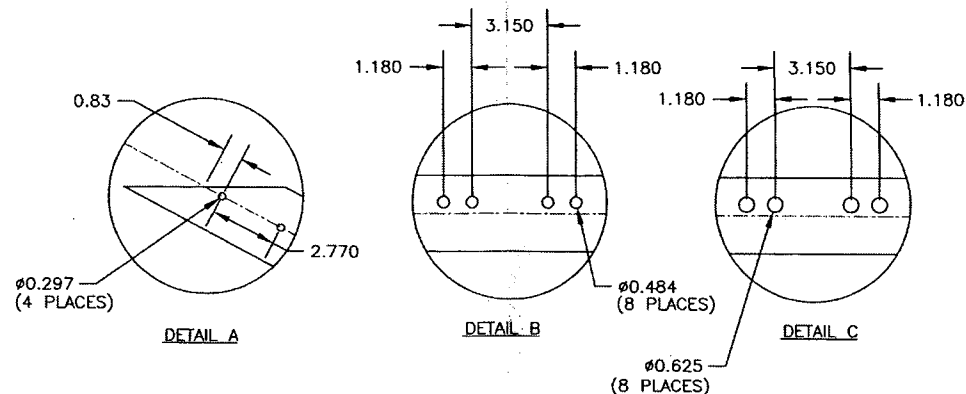


D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)

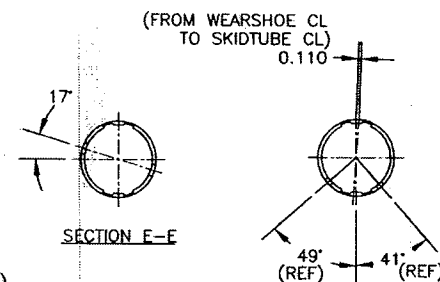


D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)

D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES
ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



SECTION F-F

RELEASED
98.12.16 DS

EFFECTIVE	DEOS
DES 9173 98.01.19 DS	DES 9173 99.01.21 DS

DESIGN #	DRAWN BY CP	DART DART AEROSPACE USA, INC. BELLEVUE, WA	REV. C
CHECKED #	APPROVED KE		
DATE 98.11.18	DRAWING NO. D2750	SHEET 3 OF 4	SCALE 1:20
	TITLE 350 SKIDTUBE ASSEMBLY		

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NO. 26043

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ENGINEERING

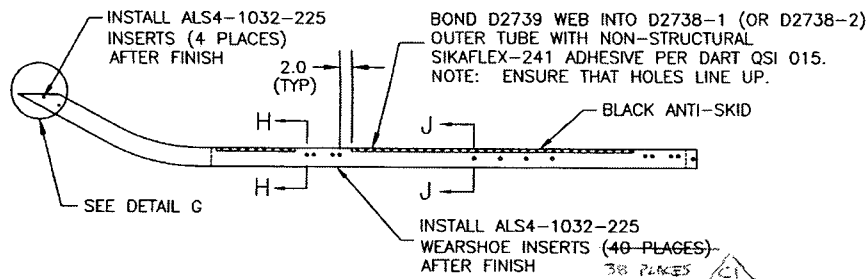
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

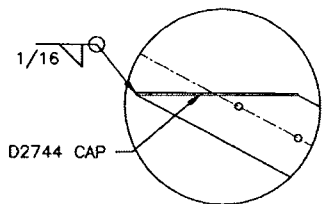
WITHOUT NOTICE

WARY ORDER

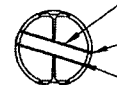
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



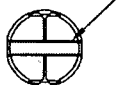
DETAIL G



SECTION H-H



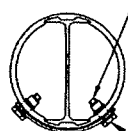
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

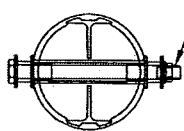
DETAIL K



USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD

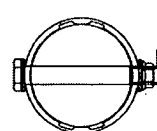
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)

DETAIL M



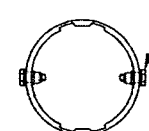
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)

DETAIL P



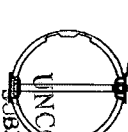
AN8-35A BOLT (1)
AN960JD816 WASHER (2)
MS21083N8 NUT (1)

DETAIL Q



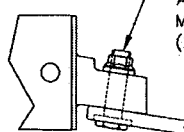
AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)

DETAIL L



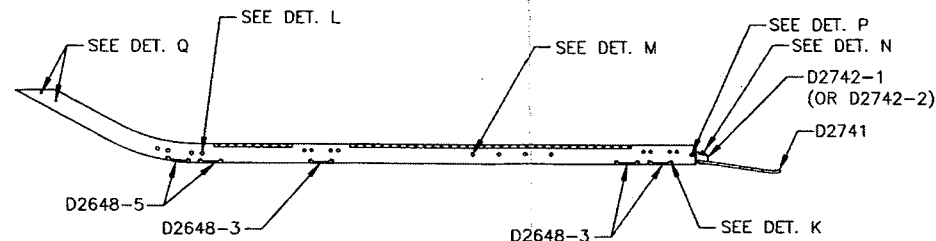
AN3-32A BOLT (1)
A3235-020-935 PLUG (2)
MS21042L3 NUT (1)
(4 PLACES, FOR D2750-041/-042 ONLY)

DETAIL N

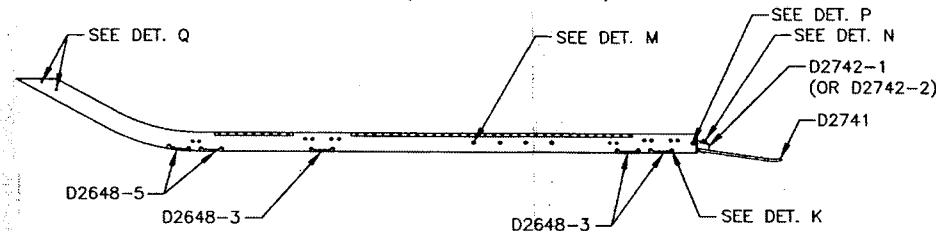


AN8-16A BOLT (1)
AN960JD816 WASHER (1)
MS21083N8 NUT (1)
(2 PLACES)

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



RELEASED
98.12.16 DS

EFFECTIVE	DEOs
180 9133 98.01.19 DS	180 9157 98.10.21 DS

DESIGN 	DRAWN BY 	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	REV. C
CHECKED 	APPROVED 	DRAWING NO. D2750	SHEET 4 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

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Jason Murdoch

From: Peggy McDonald [peggy@darths.com]
Sent: Tuesday, October 16, 2007 2:30 PM
To: 'Stavley, Stuart'
Cc: 'Jason Murdoch'
Subject: RE: SKID TUBES / ERA
Follow Up Flag: Follow up
Flag Status: Red

Please advise.
Peggy

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: October 16, 2007 11:28 AM
To: 'Peggy McDonald'
Subject: RE: SKID TUBES / ERA

Good day, Peggy. All is well? I have not yet received a response to this e-mail. Also, for me to scrap, or what ever may happen to the tubes, a return authorization will have to be issued for traceability reasons.
Thank you and have a super day.

jmurdoch@dartaero.com
Q.C. COORDINATOR

From: Peggy McDonald [mailto:peggy@darths.com]
Sent: Thursday, October 11, 2007 1:14 PM
To: 'Stavley, Stuart'
Cc: 'Jason Murdoch'
Subject: FW: SKID TUBES

Good Afternoon,

Please confirm that DART is to destroy the following parts that have been returned to DART. Originally, these were returned for repair, however we are unable to repair parts and we have now been advised to scrap these parts.

P/N D350-636-013 B/N 26099
P/N D350-636-014 B/N 26103

Please reply all, Jason Murdoch who is copied on this email is the QC Coordinator at DART and will address this issue upon receipt of your email.

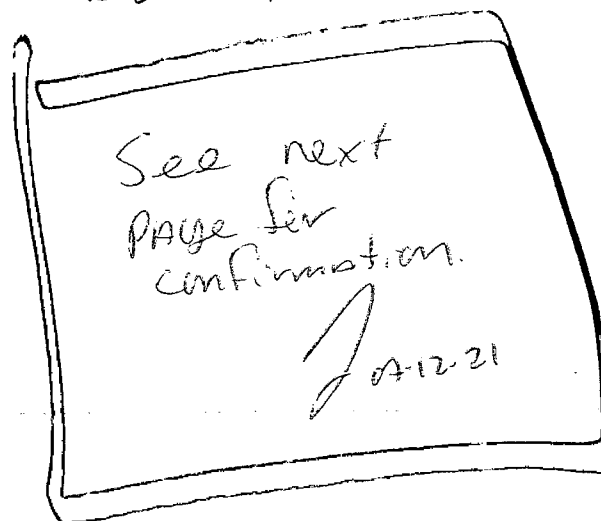
Best regards
Peggy

From: Jean Kerr [mailto:jean@darths.com]
Sent: October 11, 2007 10:44 AM
To: Peggy McDonald
Subject: FW: SKID TUBES

FYI

12/21/2007

D350-636-013
B 26099



Jean Kerr
Administrative Assistant
Dart Helicopter Services

From: Kussman, Thomas [mailto:tkussmann@erahelicopters.com]
Sent: October 4, 2007 2:16 PM
To: Jean Kerr
Cc: Church, Ricky; Bourriague, Frank; Davis, James
Subject: RE: SKID TUBES

Jean,

Please scrap on site. Thanks!!

Tom Kussmann

From: Jean Kerr [mailto:jean@darths.com]
Sent: Thursday, October 04, 2007 11:42 AM
To: Kussman, Thomas
Cc: 'Jason Murdoch'; 'Dale Trepanier'
Subject: RE: SKID TUBES

Dear Tom,

We hope everything is great with you!!

Unfortunately **DART** is not an approved repair center.
Please confirm how you wish to have these skid tubes returned to your facility.

If you require additional information, please feel free to contact us. **DART**
is always pleased to assist you.

Have a wonderful day!!

Best Regards!!

Jean Kerr
Administrative Assistant
Dart Helicopter Services

From: Kussman, Thomas [mailto:tkussmann@erahelicopters.com]
Sent: October 4, 2007 8:55 AM
To: jean@darths.com
Subject: SKID TUBES

Jean,

Good morning, would you please send me your shipping address so I can send the repair orders, also if you will include your fax I will get you a copy today.

Regards,

12/21/2007